

Aero Design Ltd.

Work Order Control Sheet

Work Order#: 2017-201

Date Opened: 23 November 2017

Title: Fabrication

Aircraft OEM: Multiple

Aircraft Model: Multiple

Product Type: Cargo Basket

Product Model: Lid Handle Bracket

Quantity: 126

Work Order Contents

Work Order/Build Sheets (Procedures Provided)
Additional Work Sheets (Standard Practice)
Drawings (See List Below)
Parts Distribution Sheet
Sub Component Tags
Completed Certification
Time Sheet (R&D)
Notes

Initial or N/A

JC
N/A
JC
N/A
N/A
N/A
DM
N/A
N/A

Build Sheet Contents

Tasks Initialled
Dual Inspections Initialled

Initial or N/A

CB/JC
N/A

Drawing List

Drawing #	Rev #	Description	Initial or N/A
84263	0	Lid Handle Provisions	JC

Traveller

Initial or N/A

Component Completion

Quantity Complete on This Work Order
Quantity Incomplete on This Work Order
Further Processing Required Before Release
Release to Stock as Components

As Instructed

126
N/A
N/A
N/A

Certification

Form One Completed
Serviceable (Green) Tag Completed
In Process (Yellow) Tag Completed
Unserviceable (Red) Tag Completed
Parts Placed in Stores for Distribution

Initial or N/A

N/A
DM
N/A
N/A
N/A

Additional Documentation

Documentation of a minor change
Non-Conformance Report Required
Service Difficulty Report Required

Initial or N/A

N/A
N/A
N/A

Billing

Local (Aero Design)
Research and Development
Third Party

Initial or N/A

JC
N/A
N/A

Notes:

Work performed by:
ICC / Dual Inspection performed by:
Work Order closed by:
Form 20.D.03

Print: David Martyn
Print: N/A
Print: C. BRANDER / S. CLARKE
Rev. Original 23 Sep 2014

Sign: [Signature]
Sign: [Signature]
Sign: [Signature]

SCA: AD-05
SCA:
SCA: AD02

Date: Nov 24/2017
Date:
Date: 24 Nov 2017

COMPONENT – LID HANDLE BRACKET ASSEMBLY

General

These instructions apply to all cargo basket lid handle brackets. Refer to the following drawings, at the current revision, for dimensions and details:

All Models: 84263, Rev. 0

Work Order: 2017-201

Date Open: 23 Nov 2017

Complete
(initial or SCA #)

AD
73-04
05

1. Welding

- a. Gather stock components

36275-02 Support Pin PO/WO # 15073

36273-01 Lid Bracket PO/WO # 17008

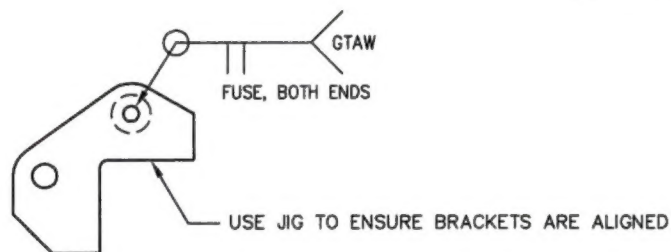
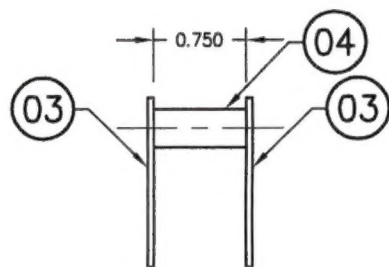
- b. Assemble two Lid Brackets with one Support Pin on fixture to maintain alignment of brackets.
c. Fuse weld tips of support pins.
d. Green tag completed assemblies and place into stock

Quantity Produced 126

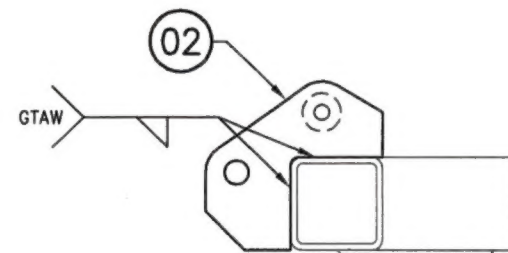
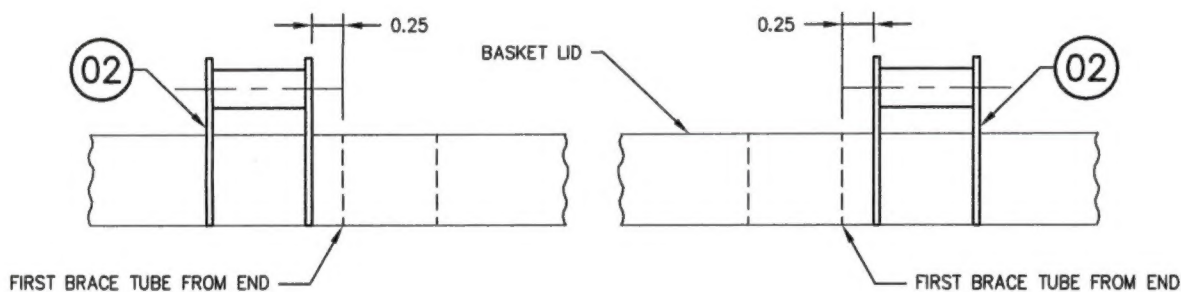
2017-201

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REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE - CREATED FROM 84262 REV. 1	BJC	14/02/2014



02 HANDLE BRACKET ASSEMBLY



01 LID HANDLE PROVISIONS ASSEMBLY

NOTES:

1. REMOVE ALL BURRS AND SHARP EDGES.
2. WELDING TO BE COMPLETED BY GTAW METHOD TO AMS2685C USING ROD CONFORMING TO ER308L OR EQUIVALENT.

1		36275-02	04	SUPPORT
2		36273-01	03	LID BRACKET
2		84263-02	02	HANDLE BRACKET ASSEMBLY
		84263-01	01	LID HANDLE PROVISIONS ASSY
02	01	PART NO.	ITEM	DESCRIPTION
QTY	QTY	LIST OF MATERIALS		

APPROVALS	DATE
DRAWN: JEFF CLARKE	14 FEB 2014
CHECKED: JASON REKVE	

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES.
TOLERANCES ON:
DECIMALS ANGLES
X.XXX ±0.010 ±1/2°
X.XX ±0.03
X.X ±0.1



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HELICOPTER CARGO BASKET
LID HANDLE PROVISIONS ASSEMBLY

SCALE 1 : 1	DWG. SIZE	DWG. NO.	REV.
SHEET 1 OF 1	A3	84263	0